



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2891-1
Job Sheet 173683



Part No: D2891-1

Job Qty: 10 ea

Part Name: Support 2.25



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/6/18

Job Tracking No:

Due Date: 4/16/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP C 02.11.26 Added P/O KJ IPP D 08.03.19 Re-format EC verified: DD IPP Rev:E 11.08.04 as per dwg rev.B DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	4/13/18	4/13/18	0.00	0.00	Start Up Machining-1		Kt 18-06-04
100	CNC Vertical Machining	10 pcs	4/14/18	4/14/18	0.41	8.20	HAAS1-2		Kt 18-06-04
110	QC	10 pcs	4/14/18	4/14/18	0.00	0.00	QC2 Machining-1		Kt 18-06-04
120	QC	10 pcs	4/14/18	4/14/18	0.00	0.00	QC8 Machining-1		MP 18/06/05
130	Crosstubes	10 pcs	4/16/18	4/16/18	0.00	0.47	Crosstubes-2		MD 07/06/2018
140	QC	10 pcs	4/16/18	4/16/18	0.00	0.00	QC3		38
170	Packaging	10 pcs	4/16/18	4/16/18	0.00	0.00	Packaging3-1	LG050	AP JUN 12 2018
180	QC21-SA	10 Ea	4/16/18	4/16/18	0.00	0.00	QC21		21 JUN 12 2018

Part Op 100 - 1-Machine as per Folio FA046

Descriptions: 130 - Per note 8 on page 1 of dwg D2891, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 24H of cure time. M138676 exp 11/18
170 - LOCATION : LG052

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
DSK076	D2891-1 Turning Detail	5 Ea (.5 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	DSK076	5	10	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	2.250 Support	0.188Inches ± 0.000	0.000 0.188		
2	2.250 Support	0.240Inches ± 0.000	0.000 0.240		
3	2.250 Support	0.115Inches ± 0.000	0.000 0.115		
4	2.250 Support	0.040Inches ± 0.000	0.000 0.040		
5	2.250 Support	0.010Inches ± 0.000	0.000		

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

			0.010
6	2.250 Support	0.240Inches $\pm$ 0.000	0.000 0.240
7	2.250 Support	0.290Inches $\pm$ 0.000	0.000 0.290
8	2.250 Support	0.115Inches $\pm$ 0.000	0.000 0.115
9	2.250 Support	0.454Inches $\pm$ 0.000	0.000 0.454
10	2.250 Support	2.779Inches $\pm$ 0.000	0.000 2.779
11	2.250 Support	0.240Inches $\pm$ 0.000	0.000 0.240
12	2.250 Support	1.002Inches $\pm$ 0.000	0.000 1.002
13	2.250 Support	0.053Inches $\pm$ 0.000	0.000 0.053
14	2.250 Support	0.257Inches $\pm$ 0.000	0.000 0.257
15	2.250 Support	1.663Inches $\pm$ 0.000	0.000 1.663
16	2.250 Support	0.053Inches $\pm$ 0.000	0.000 0.053
17	2.250 Support	0.022Inches $\pm$ 0.000	0.000 0.022

Plex 3/6/18 12:50 PM Dart.lajeunesse.marie

DART
AEROSPACE

Container No: S077442



Part: D2891 - 1

Job No: 173683

Serial No/Batch: S077442

Revision:

Inspector:

Exp Date: 06/04/2018

Instructions:

1470 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/04/18

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

DART AEROSPACE LTD		Work Order:	173683
Description: Ø2.250 Support		Part Number:	D2891-1
Inspection Dwg: D2891	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.188	0.193		0.188	0.188	0.188	0.188	0.188
AB	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AC	0.115	0.150		0.125	0.125	0.125	0.125	0.125
AD	0.040	0.060		0.048	0.048	0.048	0.048	0.048
AE	0.010	0.020		0.010	0.010	0.010	0.010	0.010
AF	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AG	0.290	0.310		0.300	0.300	0.300	0.300	0.300
AH	0.115	0.150		0.140	0.140	0.140	0.140	0.140
AI	0.454	0.474		0.464	0.464	0.464	0.464	0.464
AJ	2.779	2.789		2.784	2.781	2.784	2.781	2.784
AK	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AL	1.002	1.042		1.039	1.038	1.038	1.035	1.039
AM	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AN	0.257	0.262		0.257	0.257	0.257	0.257	0.257
AO	1.663	1.683		1.674	1.674	1.674	1.674	1.674
AP	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AQ	0.022	0.042		0.032	0.032	0.032	0.032	0.032
AR								
AS								
AT								
Accept/Reject								

Measured by:	DAS 1X	Date:	2018-06-03
Audited by:	9-8 an	Date:	18/06/05
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.09.26	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 173681
Description: Ø2.250 Support		Part Number: D2891-1
Inspection Dwg: D2891	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.188	0.193		0.188	0.188	0.188	0.188	0.188
AB	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AC	0.115	0.150		0.125	0.125	0.125	0.125	0.125
AD	0.040	0.060		0.048	0.048	0.048	0.048	0.048
AE	0.010	0.020		0.010	0.010	0.010	0.010	0.010
AF	0.240	0.260		0.250	0.250	0.250	0.0250	0.250
AG	0.290	0.310		0.300	0.300	0.300	0.300	0.300
AH	0.115	0.150		0.140	0.140	0.140	0.140	0.140
AI	0.454	0.474		0.464	0.464	0.464	0.464	0.464
AJ	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AK	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AL	1.002	1.042		1.040	1.036	1.038	1.037	1.038
AM	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AN	0.257	0.262		0.257	0.257	0.257	0.257	0.257
AO	1.663	1.683		1.674	1.674	1.674	1.674	1.674
AP	0.053	0.073		0.063	0.063	0.063	0.063	0.063
AQ	0.022	0.042		0.032	0.032	0.032	0.032	0.032
AR								
AS								
AT								
Accept/Reject								

Measured by: DAS 1 KT	Date: 2018-06-04
Audited by: 9-89 AK	Date: 18/06/05
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	
C	12.09.26	Dwg Rev updated	KJ	